

# Work Order ID 80745

Tuesday, February 28, 2012 11:22:51 AM

**\*80745\***

*today*

Page 1

Item ID: DSI 9594-011

Revision ID:

Item Name: Fwd Ground Handling Spacer

Start Date: 2/28/2012 Start Qty: 2.00

Required Date: 2/28/2012 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: *ME*

QC:

Date: *12-02-08* Tooling:

Date: SPC (Y/N):

**\*N900040100\***

Cust Item ID:

Customer:

Setup Start **\*NS1\***

Stop **\*NS2\***

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
DSI 9594	A	<i>XSP</i>							
100		0.00							
<b>*100*</b>	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP DSI 9594-011 CHG001								<i>Sz6elze</i>
110	Pick Kit	0.00							
<b>*110*</b>									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect Kits for completeness	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

*MLJ 12/02/28*

*2x SP 12-02-28*

*(42)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 80745**

Tuesday, February 28, 2012 11:22:51 AM

**\*80745\***

Page 2

Item ID: DSI 9594-011

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Fwd Ground Handling Spacer

Start Date: 2/28/2012 Start Qty: 2.00 **\*2\***

Cust Item ID:

Required Date: 2/28/2012 Req'd Qty: 2.00 **\*2\***

Customer:

Reference:

Approvals: Process Plan: Date:

Run Start **\*NR1\***

QC: Date:

Stop **\*NR2\***

Tooling:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

130

0.00

**\*130\***

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP DSI 9594-011

Location: FG 020*12/2/28 (2)*

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

*MLJ 12/02/28**MF 12-02-28*

# Picklist Print

Tuesday, February 28, 2012 11:22:50 AM

Work Order ID: 80745

Parent Item: DSI 9594-011

Parent Item Name: Fwd Ground Handling Spacer

Start Date: 2/28/2012

Required Date: 2/28/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.02.27 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2579  
Crossbolt Spacer

Manufactured No

110 Each 109.0000

4

8

12-02-28

Status

Location

Loc Qty

Loc Code

LG001

109

62400

22

70761

3

72199

1

72672

7

76002

21

78371

55

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 80745

Tuesday, February 28, 2012 11:22:51 AM

**\*80745\***

*today*

Page 1

Item ID: DSI 9594-011

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Fwd Ground Handling Spacer

Start Date: 2/28/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 2/28/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

*12-02-08*

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

Draw Nbr

Revision Nbr

DSI 9594

A

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP DSI 9594-011 CHG001

*MLJ 12/02/28*

*(Signature)*

110

Pick Kit

0.00

**\*110\***

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

**\*120\***

QC

Memo

0.00

Quality Control

REFERENCE ONLY

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D119-646 REV. B,  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D119-646 REV. 1 OR EARLIER,  
REF. FAA STC SR02024SE

## 1.0 PURPOSE

The purpose of this DSI is to provide instructions for customers to add fwd ground handling holes to their D119-646-XXX skid tubes using the DSI 9594-011 Kit. One kit modifies 2 skid tubes.

## 2.0 PROCEDURE

Modify the skid tubes as follows:

- 2.1 Rotate the D3407-041 Tow Ring to the vertical position as necessary.
- 2.2 Mark holes in the center ridge as shown in Figure 1. Drill through skid tube with Ø 0.500" (12.7 mm drill), and countersunk to Ø 0.650 x 100°, two places per side.
- 2.3 Deburr holes. Touch up affected area with chemical film material (Alodine 1200 or 1201) per MIL-C-5541.
- 2.4 Bond D2579 spacers into the Ø 0.500 holes center in the skid tube using Magnobond 6398. Grind flush prior painting as shown in Figure 1.
- 2.5 Apply one coat of MIL-P-85582 or MIL-P-2337 primer and 2-3 coats of MIL-C-83285 polyurethane coat to match original finish.
- 2.6 Repeat steps 2.1 to 2.5 for opposite skid tube.

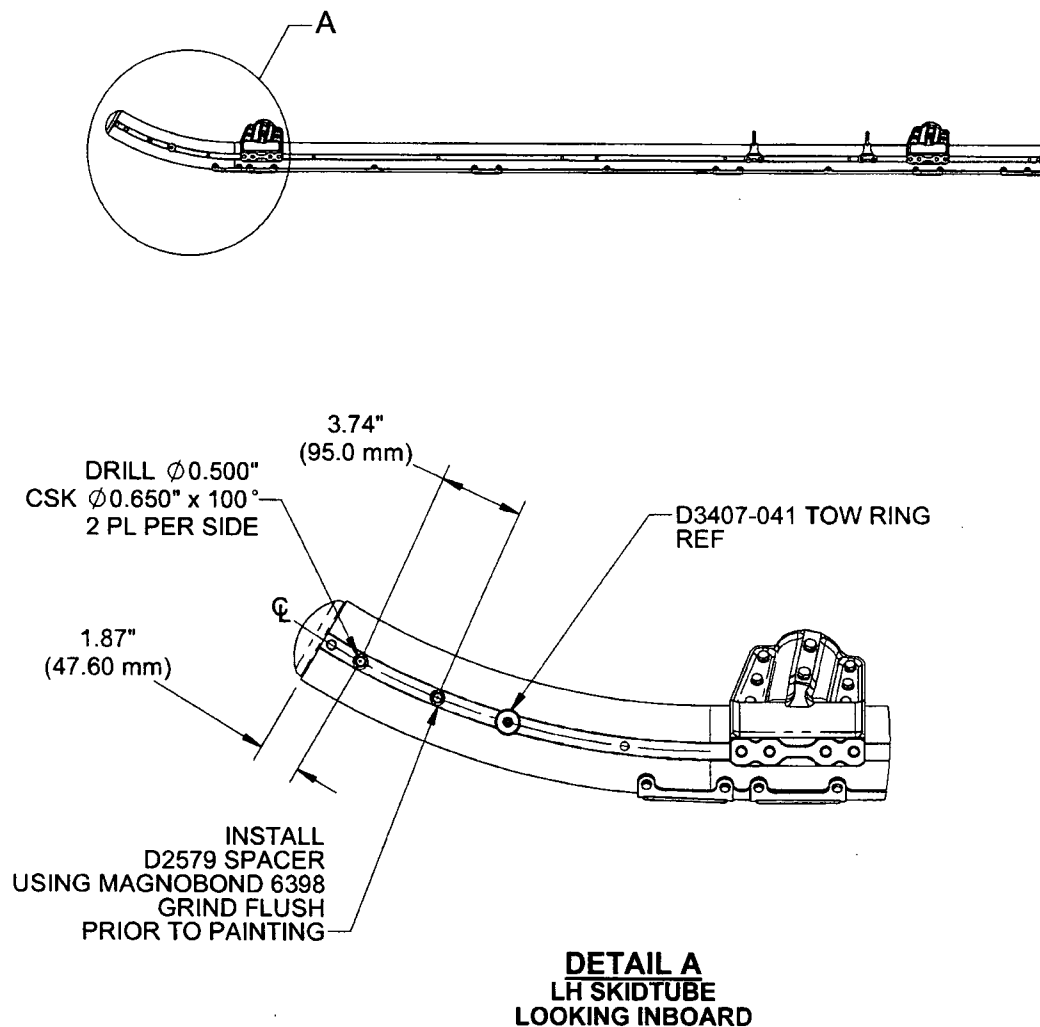
## 3.0 PART LIST

Qty -011	PART NUMBER	DESCRIPTION
X	DSI 9594-011	FWD GROUND HANDLING SPACER KIT
4	D2579	CROSS BOLT SPACER

## 4.0 WEIGHT AND BALANCE

This modification has negligible effect on weight and balance.

A	NEW ISSUE	RF	12.02.03
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9594	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FWD GROUND HANDLING SPACER KIT	NTS
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**FIGURE 1. MODIFIED D119-646-XXX SKIDTUBE**

DESIGN	RF	<b>DART AEROSPACE USA, INC</b> KENT, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9594	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FWD GROUND HANDLING SPACER KIT	NTS
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